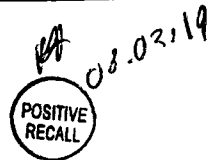


Date: Friday, 01/02/2008 9:28:51 AM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : AFT BASE  
 Job Number : 37138  
 Estimate Number : 13033  
 P.O. Number :  
 This Issue : 01/02/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D36519  
 Drawing Number : D3651 REV.B U/R  
 Project Number : N/A  
 First Issue : / / Type : SMALL /MED FAB Drawing Revision : B U/R  
 Previous Run : 35847 Material :  
 Due Date : 08/02/2008 Qty: 2 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev:A New Issue 07-09-27 DD verified by: EC  
 Est Rev:B ECN 1113P 08-01-22 DD



## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S26GA 304/316 0.018 SHEET



Comment: Qty.: 0.4526 sf(s)/Unit Total: 0.9051 sf(s)

304/316 SS sheet 26 ga (0.018" thick)

Batch: 106996 IB 8-2-4

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3651

Dwg Rev: PRE.L

Prog Rev: PRE.L

2-Deburr if necessary

IB 8-2-4



IB 8-2-4

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



IB 8-2-4

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



ENGINEERING  
 APPROVAL  
 LE 08-03-13

Comment: SECOND CHECK

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: PPP 38103 PC 8/3/18 @ IB 08-03-12 @

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 01/03/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 01/02/2008 9:28:51 AM

User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BASE

Job Number: 37138

Part Number: D36519

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08 03 18

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 8.6314

POSITIVE RECALL  
EFFECTIVE

01/02/07

AUTH

RELEASED

49

DATE

01/05/09

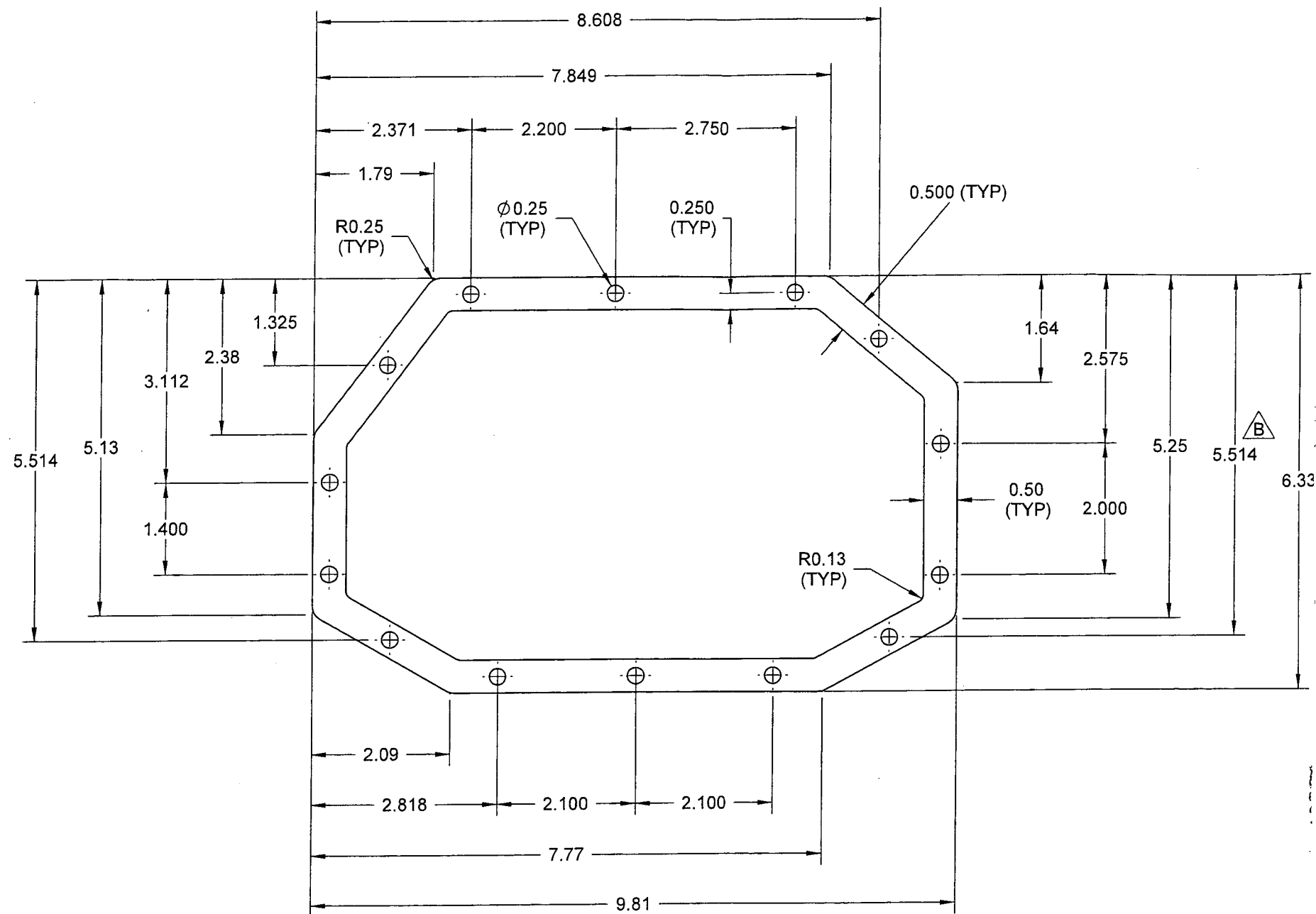
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**D3651-9 INSIDE DOUBLER**

**PRELIMINARY ISSUE**

UE 08.01.18

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs


DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	UE	DRAWING NO.	REV. B
MFG. APPR.	MNO	D3651	SHEET 7 OF 9
APPROVED		TITLE	SCALE
DE APPR.		AFT BASE ASSEMBLY	1:2
DATE	08.01.07	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

DART AEROSPACE LTD		Work Order:	37138
Description: AFT BASE		Part Number:	D36SI-9
Inspection Dwg: D36SI-9 Rev: PREL		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

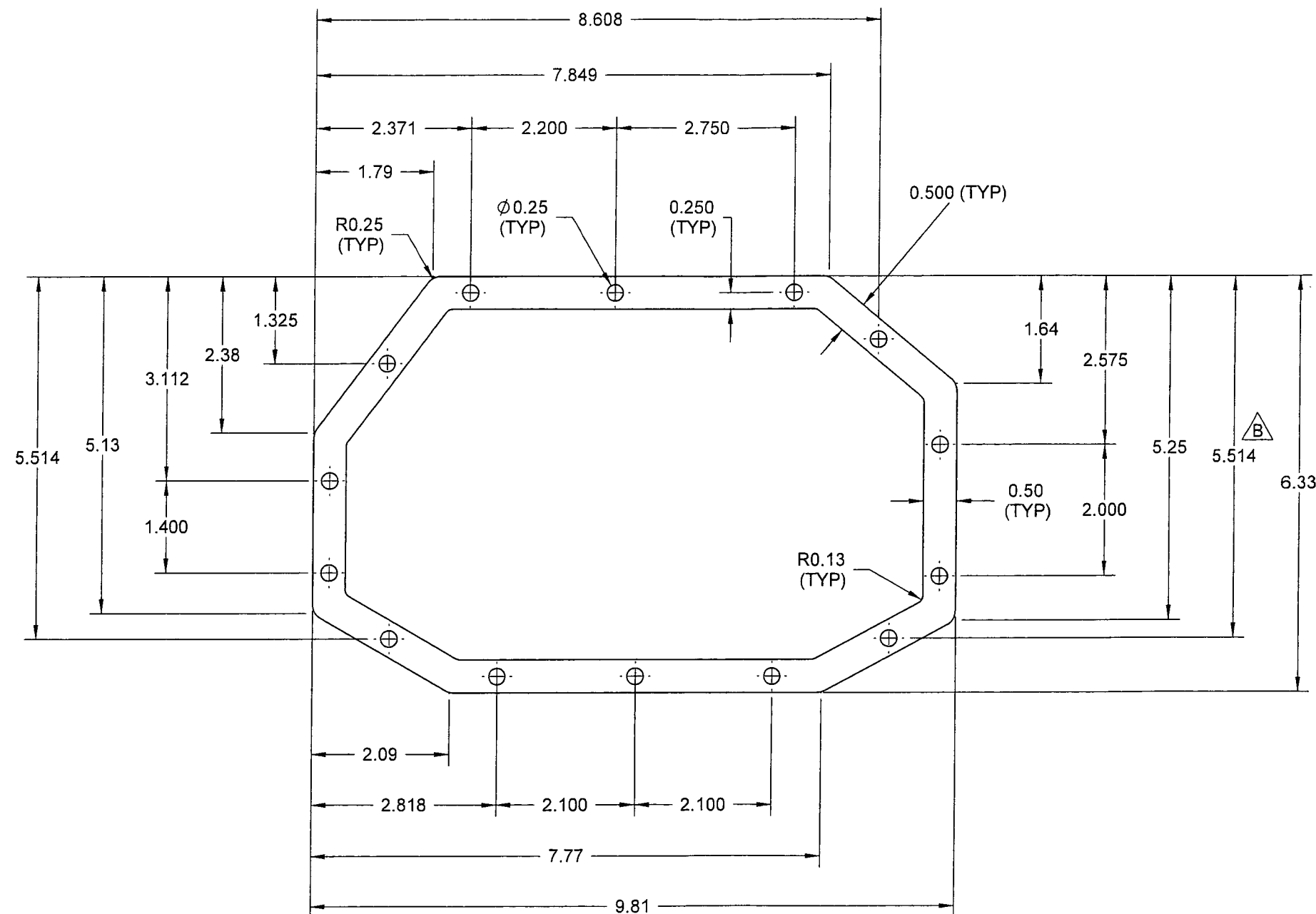
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .250	+0.005 -0.001	.253	✗			
.250	+/- .010	.250	✓			
.500	+/- .010	.506	✗			
6.33	+/- .030	6.338	✗			
9.81	+/- .030	9.81	✗			
2.818	+/- .010	2.819	✗			
2.100	+/- .010	2.103	✗			
2.100	+/- .010	2.102	✗			
2.575	+/- .010	2.579	✗			
2.000	+/- .010	2.00	✓			
5.514	+/- .010	5.514	✓			
2.756	+/- .010	2.753	✗			
2.200	+/- .010	2.196	✗			
2.371	+/- .010	2.375	✗			
1.325	+/- .010	1.325	✗			
3.112	+/- .010	3.112	✓			
1.400	+/- .010	1.402	✗			
5.514	+/- .010	5.514	✓			

Measured by: RB	Audited by: 	Prototype Approval: LE
Date: 8-2-4	Date: 08/2/04	Date: 08-03-13

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	





**D3651-9 INSIDE DOUBLER**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	WLE	DRAWING NO.	REV. B
MFG. APPR.	WLE	<b>D3651</b>	SHEET 7 OF 9
APPROVED	WLE	TITLE	SCALE
DE APPR.	WLE	<b>AFT BASE ASSEMBLY</b>	1:2
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